

Date: Wednesday, 18/04/2007 4:00:59 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE LH 206A/B
Job Number	: 24803 ✓		
Estimate Number	: 10801	Part Number	: D206642611 ✓
P.O. Number	: <i>N/A</i>	Drawing Number	: N/A
This Issue	: 18/04/2007 S.O. No. : <i>N/A</i>	Project Number	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Revision	: N/A
First Issue	: 21/11/2005 Type : LANDING GEAR	Material	:
Previous Run	: 24804	Due Date	: 15/01/2006 Qty: 1 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est Rev:B 05.10.27 Revised pick list KJ/EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

*KS*

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-611CHG001

*no S.S. wearplates
on ASS'y ok. per chg01*

2.0 24803A FLOAT SKIDTUBE HIGH GEAR 206 A/B



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B

3.0 D206651041 206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) ✓
 206 A/B GHW Kit *B27963* ✓

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Pick:

Qty Part Number Description Batch

1 D206-651-041 GHW Adapter *B31298* ✓

5.0 D26651 Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Pick:

Qty Part Number Description Batch

2 D2665-1 Saddle *B27965* ✓*PO 7/4/19*

Date: Wednesday, 18/04/2007 4:01:00 PM
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Job Number: 24803

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle B28603 ✓ ✓

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw B26481 ✓ ✓

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer B28259 ✓ ✓

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer B29199 ✓ ✓

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer B24583 ✓ ✓

6 7/4/18

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	AN3C36A	
------	---------	--



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 AN3C36A Bolt M19349 ✓

12.0	AN3C41A	
------	---------	--



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN3C41A Bolt M18918 (1X) M19349 (7X) ✓

13.0	AN4C6A	Bolt
------	--------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt M162039 ✓

14.0	AN5C7A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C7A Bolt M19185 ✓

15.0	AN5C11A	
------	---------	--



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt M18918 ✓

16.0	AN5C13A	
------	---------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C13A Bolt M18918 ✓

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Job Number: 24803

Part Number: D206642611

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0 AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M18918 ✓

18.0 AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C35A Bolt M18918 ✓

19.0 AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN6C44A Bolt M103964 ✓

20.0 AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 AN960C10L Washer M101692 ✓

21.0 AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M103641 ✓

Handwritten signature/initials

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Job Number: 24803

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M189/8 (4X) ✓

M19349 (4X) ✓

23.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt M19/85 ✓

24.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M19699 (16X) ✓

M102545 (1X) ✓

25.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M102959 ✓

26.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M101418 ✓

✓

P07/4/18

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Job Number: 24803

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut

M103693 - ✓

✓

28.0

NAS1515H3L

WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 NAS1515H3L Washer

M18099 (10X) ✓

M103325 (8X) ✓

29.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

M101428 - 1 ✓

30.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 NAS1515H5

Washer M101064 - ✓

✓

✓

31.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 NAS1515H5L

Washer M100680 (3X) ✓

M101925 (5X) ✓

P07/4/19 (1)

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Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 24803

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

[Handwritten signature] u 07/04/20

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

Location: _____

PPP Rev: _____

[Handwritten signature] ①

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

[Handwritten signature] ①

Job Completion



[Handwritten signature] u 07/05/21



[Handwritten signature] 7/4/20

Date: Monday, 11/21/2005 2:42:59 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B
 Job Number : 24803A
 Estimate Number : 10803
 P.O. Number : N/A Part Number : D206642641
 This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D3288 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 24804A Material : N/A
 Due Date : 1/15/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ringEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG001

N/A

2.0 D26001240 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube 24841

DPOG-3-28

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler 2242063E 06-03-29

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to length as per Dwg D3288 and Deburr ends.

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT 8818 Drill 3/16" pilot holes as per D3288

4-Open aft end cap holes to Ø0.208" as per Dwg D3288

Dart Aerospace Ltd

W/O:

DATE:

WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: _____		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Remove inner indexing ridge on aft end of skidtube as per Dwg D3288. Deburr Aft end.

DP06-3-28

6-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole and drill GHW hole to # 40 as per Dwg D3288

BE 06-03-29 (1)

7-Remove DT8732 drill Jig and Deburr # 40 holes

BE 06-03-29 (1)

8-Insert D3286-1 doubler using DT8732 & D206-642-641-T1. Insert tool, locate doubler off of 3/16" holes, then remove DT8732

BE 06-03-29 (1)

9-Transfer drill doublers to # 30 working from the center out. Cleco while drilling to ensure stability of doublers as per Dwg D3288

BE 06-03-29 (1)

10-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3288

BE 06-03-29 (1)

11-Remove doublers, identify orientation, then attach them to the workorder

BE 06-03-29 (1)

12-Remove indexing ridge as per Dwg D3288.

BE 06-03-29 (1)

13-C'sink GHW rivet holes as per Dwg D3288

BE 06-03-30 (1)

14-Open GHW holes to Ø0.625" (in tube only) as per Dwg D3288

BE 06-03-30 (1)

15-Deburr Ø0.625" GHW holes

BE 06-03-30 (1)

16-Open Ø0.313" crossbolt spacer holes using DT8746 as per Dwg D3288

DP06-6-1

17-Open Ø0.375" crossbolt spacer holes using DT8747 as per Dwg D3288

18-Deburr crossbolt spacer holes as per Dwg D3288 and blow out chips from inside the tube

N/A

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-04 (1)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1




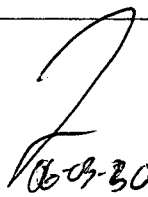

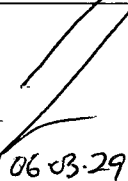
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 06-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-29	4.9	During transfer drilling the drill bit broke in the doubler. The remainder of the bit slide off to the side enlarging the hole by .030.		Install brass plug and fill hole with weld as per QSI 004, grind weld flush, and re-drill. Ensure no weld residue is left on inside when installing the doubler.	BE 06-03-30	 06-03-30	 06-03-29	 06-03-29

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



for 06-05-31



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M19185 BE 06-03-30 (1)

9.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

624864 BE 06-05-31

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

BE 06-03-30 (1)

2-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

M100901 BE 06-05-31

Sikaflex expire date:

06-11-01 BE 06-05-31

Start: 1:30

Time: 06-05-31 BE 06-05-31

Finish:

6:00

(Adhere for 12 hours)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RA 06-10-13

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

DP 06-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #: Machine Or Operation: Description:

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of tube to length as per Dwg D3288

N/A

2-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3288

DP06-3-28

3-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to $\varnothing 0.297$ " (without cutting fluid)
1.250

4-Deburr

DP06-6-26

5-C'sink cross bolt holes as per Dwg D3288

14.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647

Fwd Cap

B20235 BE 06-03-29

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649

Crossbolt spacer

B29329 BE 07-01-17

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D3275-1

Crossbolt spacer

B24861 APC B21748 (5P) BE 07-01-17

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B24711 BE 07-01-17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3288 and QSI 004. Use aluminum rod.

A/R Aluminum Rod *M18839/M19101 BE 06-03-29*

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M101010 BE 07-01-17*

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod *NONE BE 07-01-17*

4-Grind welds flush to Fwd cap on top surface only.

N/A

5-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

PM 07-01-17

6-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

PM 07-01-17

19.0

QC5/9

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/01/18

PA 07.01.18

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/04/03

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/04/09

22.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate *B24574*

FL

07/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

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Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	CCR264SS33	Cherry Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

m 14651

24.0	CR3212403	Cherry Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

m 15918

25.0	D26483	Wearpad
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Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2648-3

Wearpad

B 29777

26.0	D265615	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe

B 29335

27.0	D265621	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-21 Wearshoe

B 29198

F2

07/04/10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe B29337

29.0

D32873

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-3 Wearshoe B24863

30.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B30237

31.0

MS27039C108

SCREW



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

64 MS27039C1-08Screw m19185

32.0

NAS1330C3KB116

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

64 NAS1330C3KB116 Inserts m102018 (28)

m100712 (35)

FL 01/04/10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1515H3L

WASHER



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

64 NAS1515H3L Washer m103641

34.0

AN960C10L

Inventory



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

64 AN960C10L Washer m103641

35.0

D34131

RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B24869

36.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt B38918

37.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer ~~B100651~~ B103338 FZ 07/04/16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

AN960C416L

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416L Washer

13100651

39.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw

m15194

40.0

NAS1515H4

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 NAS1515H4

Washer

m101542

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

030119

42.0

MS27039C108

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039C1-08Screw

m19185

FL

07/04/16 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:42:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #: Machine Or Operation: Description :

43.0 NAS1515H3L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer m103641

44.0 AN960C10L Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960C10L Washer m103691

45.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch: m104099

2-Install inserts & wearshoes/wearpads as per Dwg D3288. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearshoes and skidtube and a layer between wearshoes and wearpads, seal edges as required.

A/R Sikaflex-291

Sikaflex expire date: 07/10

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date: 07/10

6-Coat all exposed fastners with LPS Procyon,remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon Batch: m17168

FL

07/04/16

P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PR Date: 11/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 24803A

Part Number: D206642641

Job Number:



Seq. #: Machine Or Operation:

Description :

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

24803A

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location: _____

PPP Rev: _____

PPP 24803

12/14/30 6

48.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

12/15/01

Job Completion



12/15/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 24803
Description: Float Shield 206 A/B		Part Number: D206-642-641
Inspection Dwg: D3288	Rev: B	Page 1 of 1

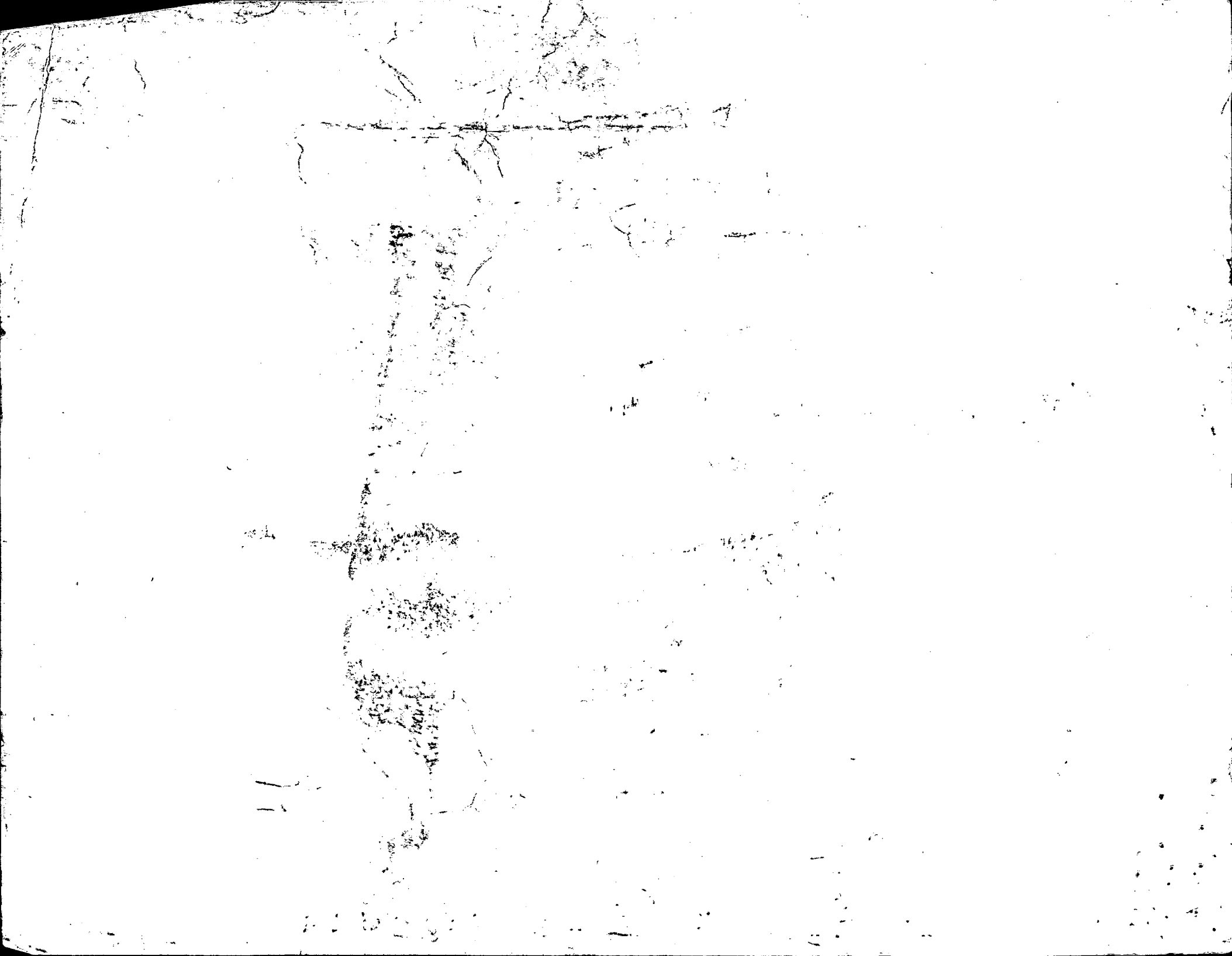
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Detail A						
5.000	±.01	5.000				
3.750	"	3.750				
1.250	"	1.250				
Detail E						
0.400	"	.400				
2.03	±.03	2.03				
15.000	±.01	15.000				
30.000	"	30.000				
5.50	±0.03 ±0.00	5.50				
15.000	±.01	15.000				
30.000	"	30.000				
6.000	"	6.000				
12.000	"	12.000				
45.49	±.03	45.49				
7.00	"	7.00				
15.96	"	15.96				
53.500	±.01	53.500				
65.27	±.30	65.27				
5.00	"	5.00				
4.9	±.100	4.9				
7.0°	±2°	7.0°				

Measured by: DP	Audited by: BE	Prototype Approval: AH
Date: 06-6-26	Date: 06-06-26	Date: 06.10.13

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



NO. 86

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A206 842241 / B 29374 A

TEST WELDS REQUIRED

BASE METAL	<u>Alum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete [] Partial [✓]	Single Weld [✓] Double Weld []	
Current	AC [✓] DC []	Backing Y [] []	
	Position	Vertical []	Up []
Sheet Groove	1G [] 2G []	3G []	4G []
Tube Groove	1G [] 2G []	5G []	6G []
Sheet Fillet	1F [] 2F []	3F []	4F []
Tube Fillet	1F [] 2F []	4F []	5F []
Crossbolt Spacer Welded into		Skid []	

TEST RESULTS

Visual Pass [✓] Fail []
Penetration Pass [✓] Fail []
Crossbolt Spacer Pass [✓] Fail []

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/01/16 Qualifier David Reed

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3288	REV. B SHEET 1 OF 3
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	

REFERENCE ONLY

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
7	D2648-3	WEARPAD
9	D2649	CROSS BOLT SPACER
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2656-35	WEARSHOE
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3287-3	WEARSHOE
1	D3289-041	FLOAT WEB
1	D2646	AFT CAP
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3429-1	WEARPAD
64	NAS1330C3KB116	INSERT
66	NAS1515H3L	WASHER
1	NAS1515H4	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
66	MS27039C1-08	SCREW
1	AN4C5A	BOLT

RELEASED
05.09.06**GENERAL NOTES:**

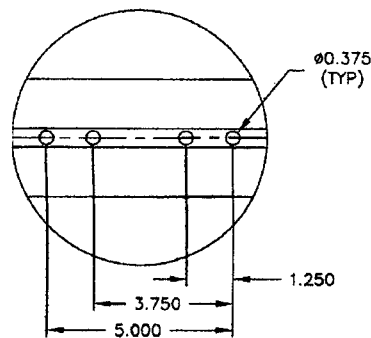
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' (Ø0.250 REF) AND C'SINK Ø0.391x100° FOR NAS1330C3KB116 INSERT USING DT3288-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

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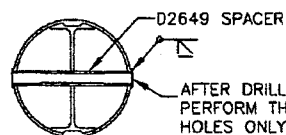
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DETAIL A: DRILL DETAIL

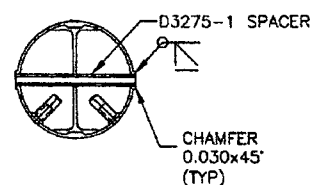


DETAIL B FOR 0.375 HOLES ONLY



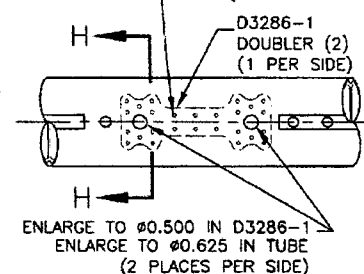
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

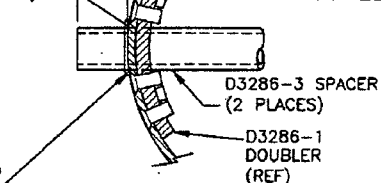


DETAIL G SCALE 1:5

DRILL #30
C'SINK 0.229x100°
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)

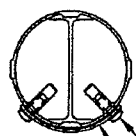


SECTION H-H NOT TO SCALE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH
WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER
USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO 0.500
4. ENLARGE HOLES IN TUBE TO 0.625
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

DETAIL D



NAS1330C3KB116 INSERT (1)
MS27039C1-08 SCREW (1)
NAS1515H3L WASHER (1)
(64 PLACES)
WEARPAD/WEARSHOE (REF)

RELEASED
05-09-06

DETAIL E

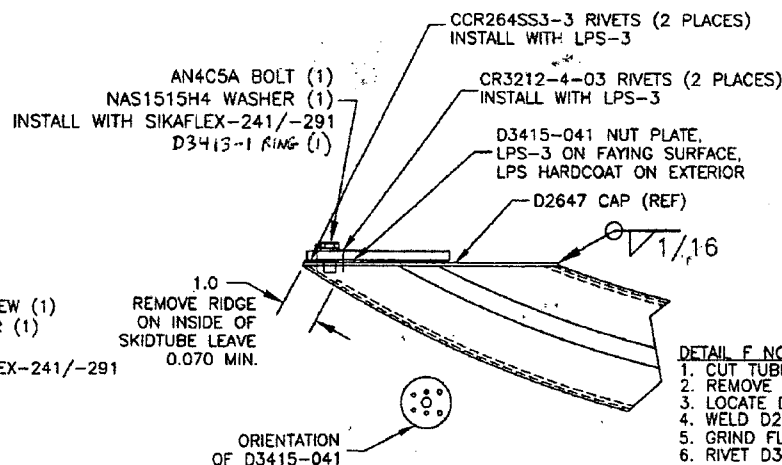
D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

MS27039C1-08 SCREW (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

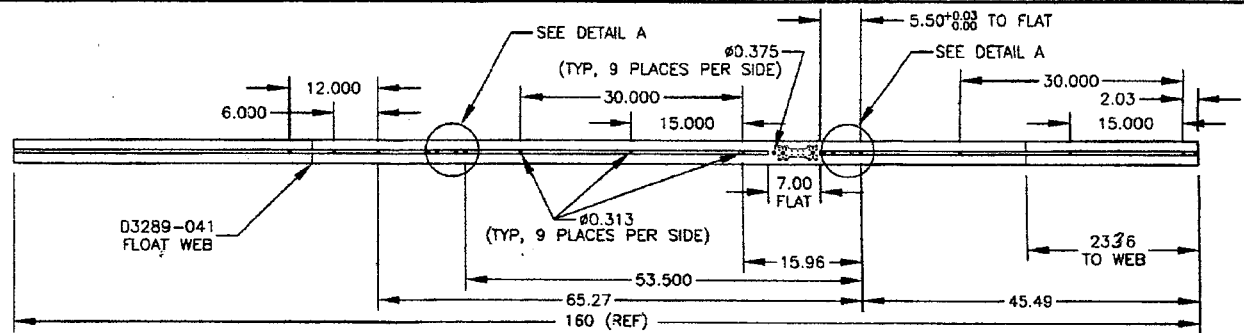
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL

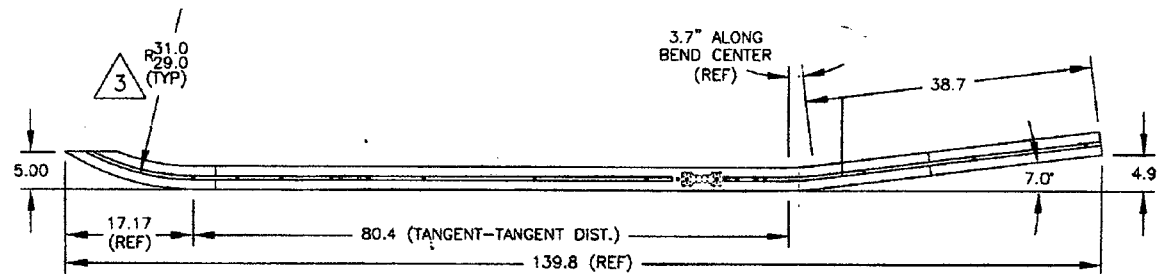


DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

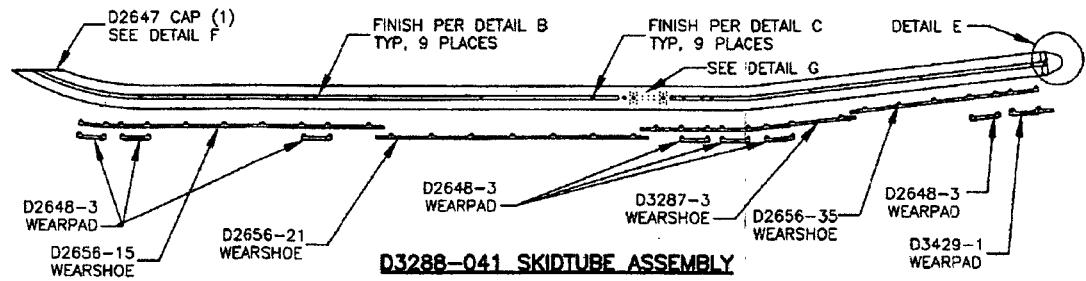
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DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY		SHEET 2 OF 3		SCALE 1 TO 3	



D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL



D3288-041 SKIDTUBE ASSEMBLY

RELEASED
05-09-06

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		DATE	05.03.16	TITLE		SKIDTUBE ASSEMBLY	SCALE
							REV. B SHEET 3 OF 3 1:15

